Notebook Series -- Notebooks by Edison and Other Experimenters
Disc Record Book No. 11
Notebook, N-16-04-27

This notebook was used by Edison during April-May 1916 for notes on experiments to improve the manufacture of disc records. The entries describe a sequence of experiments numbered from 1000E to 1055E. Most relate to attempts to print music directly onto varnished record blanks without the usual intermediate transfer process. Included are tests involving different varnish compounds, variations in the number of coats and methods of applying the varnish, and differing amounts of pressure and baking schedules. Flaws and successful results are both noted, along with the title of the musical selection used in the tests. Many entries include a summary of acceptable and unacceptable prints. Several entries pertain to efforts to print on discarded blanks; others give the results of "breaking tests" to determine the fragility of the test records. There are also references to blanks used to train workers learning to varnish or brush records. At the end of the book are calculations regarding the cost per record produced. Some notes are in the form of instructions to Sherwood T. (Sam) Moore, Archie D. Hoffman, or other employees. Additional notes on some of the experiments in this book can be found in N-16-04-26, Notebooks by Other Experimenters—Phonograph Record Experiments—Miscellaneous Disc Composition Books. The front and back covers are labeled "No 11." The pages are unnumbered. Approximately 150 pages have been used.

855
Acme Co.,
MFG. STATIONERS,
95 JOHN ST.
AND
19 PLATT ST.
NEW YORK.

April 27 / 1916

Experiments on No Transfer Record, only Condensate Varnish - Direct printing on blank -

64.5 % fibers
25.8 chalk
9.6 Lac

20 cross blanks
130 lbs phenol
12000 lbs fibers
4830 " chalk
1870 " lac
200 " or 30 gal alcohol

1412 Recorder

Weigh

Without Veneer 411 @ 433

With Weld Veneer from 1 to gram Extra.

Total Average

423 grams

1000 E

Hoffman make some blanks about 200 more ~~of~~ or less with 9/14 of Lac instead of 1 as now

~~Hoffman will at first~~

~~Mixed 24 Blanks with Hexamine~~

~~24 " 1/32 Hexamine~~

~~24 1/16 "~~

While the Resin is reduced the Alcohol is the same as when 1 Lac is used

This powder works better than any of the others in Molding

Brushing Varnish #1413
5% Lacquer & Cresol

1001 E

Make
~~50~~ 1412 blanks - Brush with
2 coats of varnish dry 2 hours
between each coat, + 2 hours after

12.
Then print direct on blank.
with 6 Tracked moulds &
6 music moulds —

Schedule. Put at contact
needle just off pin - when it
reaches 180° fahr put
pressure to 500 lbs & hold
for 12 minutes -
Cool & remove at 120
to 125° fahr

Not so good as 1002
The Extra 5 min was
an improvement.

1002 E

RCW

Use 12 blanks of 1001

Print direct on blank on following schedule -

Schedule Put at Coil at needle just off pin - when it gets to 180° fahr. put 500 lbs pressure on & hold for 20 minutes - cool & remove at 125° fahr

Pretty good but fern outpours
Mechanically good -
Surface good as Ray

NOTICE

Double brushing is an improvement over single Brushing or Coat but must be put on more Even & Clots got rid of + not filling in opals clipped -

0 11 Tested 1 broke in 2

print OK IIII IIII as far as prints is concerned
only blank so far give good prints by Eye at least

Edges all Crushed II

Var Pull off Edges IIII
that filled small spot may not sound 1
pulled off Edges & Centers both sides 1
Blank Cracked in 2 1

Surface by Eye good —

None are comel, Shellac must be brot up by alcohol that goes down in this especially porous compressed blank.
The small amount of lac permits fibres to spring up + down

1 Shinola so found to mould
Cant get off + 3 others stick around edges

Little more brittle on check test. Have reg 1412 but OK

Surface of ground blank fuzzed up + shiny with lac
note, short shot filled up + shiny much more bold Var
like 1 + 1 1/3 — will hold very

Strange

when they stick to front mould

OVER

PHENOMENON

1003 E

Use 12 blanks of 1000 E

Put two coats weld Varnish on
Drying 2 hours between
Coats or 2 hours after
use

3/4 Lac

Print direct on blank
with cracked Moulds & figure
1 good surface moulds
among them —

Schedule - Put at contact
with needle off pin when at
reaches 180 fahr, put on
500 lbs & hold for 12 minutes
Cool & remove at 125°

Sticks badly to moulds -
Cant get off by soaking in either
Alcohol or KOH and Crying
mixture of both, NaOH strong

OVER

For direct printing #1000 is best for filling 100% may be due to some excess as surface more matte + it will hold much more weld Varnish which insured a fill

1004 1413 Van 5% Carbon Black

Moore has some 1412 blanks brushed.. Baked at 130° Fahr for 5 hours

(12)

Print, with Jerg music moulds now being used

Schedule

Put at Contact needle just off pin When temp reached 180° Fahr put pressure to 500 ~~lbs~~ lbs for 12 minutes — Cool & remove at 125° Fahr

Blanks are old & not so fine surface more surface noise = smooth point matte from coarser powder made before had good screens

Mechanically good not so good as 1508 blank —

Dont fill as well as 505

Blank Cracked 1
OK ||||1
Not filled at Edge both sides 11
" " one side 11
Blank, broken + blank chipped edge 1

50% —

1005 -

Make 50 blanks 1412

Put two Coats of Varnish on
Drying two hours after each
Coat,

Use The same Varnish that
we use for flowing plates
without any Lampblack in it.

Print direct on blank with
Regular Music Moulds now
in use

Schedule - Put at contact
Needle just off the pin —
When temp reaches 180° Fahr
Put the pressure to 700 lbs
+ hold for 12 minutes
Cool + remove at 125° Fahr

Surface not quite as good
on new cracked blank as No 1008
though very slight difference

1006 -

Take 12 Direct printed records, put on one coat of Varnish dry Two hours & reprint them with Reg music moulds now in use

Schedule - Bring to contact so needle left pin —
When temp reaches 180° Fahr put pressure to 700 lbs for 12 min - Cool & remove at 125° Fahr

1007-

Reprint 12 Dunest printed records - 1001

Schedule

Bring to contact till needle leaves pin - Then when when temp reaches 180° fahr put pressure to 700 lbs for 12 minutes then cool & remove at 125° fahr

They do not reprint dont reform - film on surface stretched so much it cracks very much - & when cross each other no print must be rearranged -

NOTICE

OK. III
Poor print both sides III 1
Slight poor print one side 1

Some records have blank edge broken long 1
Same " " V 1

This is better than
1005 –
But perhaps 1½ Lac
would be better than 1 1/3
as 1508 is –

Found 1 pair moulds not
lined up which caused
one edge to flow excessively
~~a Cracked~~ sharp edge –

1008.

Take 12 Blanks Hoffman
1508 – Put two coats
reg brushing Varn on
drying 2 hours after
Each Coat,

Print direct on blank with
Reg music moulds

Schedule –
Bring to contact till needle
leaves pin, then when lamps get
to 180° Fahr put pressure to
700 lbs for 12 minutes
then Cool & remove at 125°
Fahr

Tracked blank surfaces are fair
but it still is too much must be
improved although about like Reg Production

1009

Dup of 1008

Except Change the schedule to 900 lbs pressure for 12 minutes —

OK.

Not filled - both sides opposite ~~IIII~~ ~~IIII~~ II

OK ||||
Poor point 1 side ~~||||~~
" both sides |||

1010 E

Use 12 blanks from 489 E Baked
Put one coat varnish on dry
2 hours

Print direct with regular music
moulds now in use

Schedule
Bring to Control
needle from pin — When temp
reaches 180° put pressure to
700 lbs for 12 minutes — Cool
& remove at 125°

OK IIII
Poor present 1 side - sharp or peculiar IIII
" Both sides II
Blank cracked all across I

Blank does not Even up with 700 lbs as it dont flow enough to Even up -

Surfaces on 1011 are 33% better than 1010 with only 1 Coat

NOTE

2 Coats better than one Coat

1011 E

Dup of 1010 E
But put two coats on
Drying 2 hours after Each Coat

Use same schedule as in 1010 E

Dont think there is any advantage in Baking blanks Req Schedule -

Not less than 700 lbs
Can be used -

Possibly 1508 blank
will do better -

The surfaces are as
good as Regular - +
most of surfaces noise
is in the Mould themselves

SO FAR THIS IS
Best

To get surfaces perfect if
mould is perfect would be
to raise angle of screens +
make the powder a little
finer -

1012E

Dup 1001 -

Except Change schedule
so final pressure is 700
lbs for 12 minutes

NOTICE

Nearly Every one is filled
The spots + ferns have
disappeared - only two
records show lack of
fill in small spots +
these are due to blank
as they occur opposite
on both sides

Tests for Points 11 Records

Transfer M - Moore Thread mould bad

Schedule OK IIII

Tern both sides opposite III Tern 1 side II

Both sides Poor Print 5 II

Broken Edge 1

The Music is fine, The surface on 2nd Reprint is V rating - which is better than our regular all fibre pressings -

I Expect the 3rd Reprint will be even <u>BETTER</u>

11 Records

1013 E

Reprint 12 Direct records - already having music on but before reprinting put two Coats of Weld Varnish on Dry 2 hours after each Coat, ~~Use Scotch~~

Schedule = Bring to Contact needle just off pin - When Temp gets to 180° put 800 lbs pressure on for 12 minutes Cool & remove at 125°

For Thin flowed plates

Thin Varnish No 1

15% more alcohol added to
reg Varnish 150g-508E

On this lot of Var. we use ~~15~~ instead
of 15g at to 100 Resin which is
regular Var we add 15%
more alcohol bringing the
Total alcohol up to 182.85

No 2 Var same as above
but total alcohol 198.75
instead of 15g Reg-

1014.E

Flow 100 plates with 15 cc
No 1 thin Varnish, 15% Extra
alcohol used

1015 E

Flow 100 plates with 15 cc
No 2 Thin Varnish which
has 25% Extra alcohol
added to Reg Var -

1016 = 7 months after
11-26-1916 Reexamined

(1 = V good surface
2 good surface
(3 V good surface
4 V " "

7 months show ok - very good & satisfactory
devices - far better than now

HH 11

1016 E

Fired Off to bake 3 or 4
Direct printed records up to
175 deg fahr - Taking
3 hours to bring them
up from atmospheric
temperature to 175°
Cool down in say 1 hour

Dont seem injured think
perhaps surface may be
a little harder -
Shows Direct printing
is ok as far as Rio Shield up
concerned

Oulay 11 Count was thus –
as 1 blank was cracked

OK IIII IIII

Blank ckd before it was Varnished 1

Cracked parallel at measure ¼ in 1" long
Check to moved of holes 11

Evidently as 1508 blanks made
in Lac squeezed out at Edges

1017 E

1508 Blanks – 50 blanks

Put 3 coats of varnish on blanks

use reg wold Varnish, dry
2 hours between each coat

Print with 10 pair reg music
moulds + 2 pair of tracked
moulds –

Schedule – Put at contact, needle off pin
when temp reaches 180° Fahr
put on 800 lbs for 12 min
Cool & remove at 125° Fahr

Flat edges not flowed out

Quality of 17 & 1018 is
Very poor - Rotten

than regular records for musical quality
1017 & 1018

first grooves to perfectly
fill & perfect,

Surfaces fair -
Only wants little
improvement in
surfaces

Will look for quality
of Music

Note difference a squirreling Edge blank to
flat Edge blank

1018 E

These all three release

Duplicate of 1017 E

Schedule changed so
they are cooled down
Cold before taking from
the press —

OK

1 pull out. slush to mandrel 1

91.5

Also note 1017 just as good
taken out 125° except at hole

1019 E

Hoffman to make a gallon of 5% Lampblack welding Varnish, same as now used but with the regular amount of Sandrac used in Reg Var.

Some look like poor print + bad but its in cracks + sounds OK –

PHENOMENON

Think this is 1598 [illegible] from [illegible] Hoffman

The quality of the music is very much different with same tunes as it is on Rag Thickness Blank

The latter is fine while the thick blank 1020 sounds as if slipping + it is not enjoyable overtones gone apparently not so clear, something radically wrong

April 29/1916

1020 E Printed with Even Mould fund

12 Blanks 1/16 thicker than reg 1412 = put on One Coats Varnish Dry 1 hour ~~after 1st Coat a 1 hour after 2d Coat~~, Rubber press 500 lbs –

Use Music Moulds + 2 Tracked Moulds

Schedule Put at Contact needle off pin – When temp reaches 180° put pressure to 700 lbs for 12 min Cool + remove at 125°

OK. 100 %

These are first good prints we get from direct printing

1021 E

Dup 1020-

But with 1538

1/32 thicker -

1022 E

Hoffman make 24
1508 Blanks $\frac{1}{16}$ thicker
But use 1000 lbs
on the Rubber.

1023 E

Ms 24 1508 Blank $\frac{1}{16}$ thicker
E 1022 - made by Kaffman
with 1000 lbs on rubber
put 1 coat on of
brush varn + dry 1 hour -

Hold till further order

1024 E

1005 was the 1st print
1013 " 2nd "
3rd Reprint of 1013

Duplicate 1013 by putting on 2 Coats Weld Var over the record after 1st Coat Dry 2 hours - after 2nd Coat dry one hour

Print again with the musical moulds

Use same schedule as used in 1013

The broken blank record improves

~~Poor print~~
OK both sides ||||
One side OK other side Poor print |||
Poor print both sides ||||
OK music pulled out in label - 1

1025 E

2nd Reprint

Reprint 100g –

Put 2 Coats brush Var on
after 1st Coat dry 2 hours
after 2nd Coat dry 1 hour –

Print with music moulds

A Same schedule as
100g –

OK ||||, ||
Cound ||
Poor print blurr ||
Poor print 1 side forms 1

Quality on Reprint OK
surfaces V to VV –

1026 E

Hoffman

Use 1508 Powder.

Press one mould in 12" Ram press. To 700 Lbs.-

This is equivalent to 1800 lbs on small press.-

See if the rubber stands up & it is practicable

Dont use any heat

1027 E

Hoffman

Make 12 1508 blanks
Req thickness pressed
with Rubber pad in
big press at 900 lbs
+ then struck off

OK 1
Poor print 1 side |||
" " Both sides ||||
Stuck to mould ||| pulls out
Stuck Opp both sides | " "

Cant Reprint on this blank

Quality of reprint
is Even better than
our Regular record

Yet the first Print the
Quality of music was
Rotten

Reason is that all the deforming took place on 1st print & when Reprint was made there was no further deformation

2nd print

1028 E

Reprint 1020 E
Two Coats Var after 1st
Coat Dry 2 hours -
after second coat dry
1 hour

Print with special
music moulds

Same schedule as
1020 E

NOTICE

The surfaces are very fine on Reprint Rated V to VV according to moved surfaces +

The Quality is A1-

This ~~[illegible]~~ blank will I think Reprint many times

1029-E

Reprint 1003.

Give them 2 Coats weld Var- after 1st Coat Dry 2 hours. after 2nd Dry 1 hour- Use fresh Varnish

Use same schedule

Poor print 1 side III

~~OK side III~~ 2 OK.

Poor print both sides IIII

OK both sides II

As the 1st prints were bad all around Edges from sticking to mould it is probable this blank will be good for Reprints

If we are to get our good Results we'll have to use Coarser Plaster of Paris we got Plenty worth — Veneers

1030 E

Use Hoffmans 1510 blanks
Transfer with req Varnish
plates, Req Schedules
for Req 1412 blanks.

Red + blistered Ck'd 9
Angle Cracks 2
OK 1

Crushed Edges [illegible]

Edge blister Ck 11
blister both sides 1
Blister one side 111 small notched 1
Cracked 1.

This dont duplicate
our old good results nor
anywhere near it.

1031 E

Hoffman Make up 50
more blanks Reg Medium
300 lbs Rubber recovering
from #1000. 3/4" Lae

Very little flow.

1 - filled both sides - Crushed Edges
2 " " " Varn flaked off edge
3 " " " "
4 OK
5 OK - small piece Edge broken off
6 OK " " flaked Var at Edge

Flaking off of varnished surface film at Edges is because it sticks to print mould

Surface on some good others bad - latter probably due to bad Varnishing + want of more

Quality fair but dont think it clean as much thin non flowing blank

1032 E

Use 6 of 1023 E

Put on 2 Coats ~~[illegible]~~ Reg

Weld Varnish —

After 1st Coat Dry 2 hours
" 2nd " " 1 hour

Print direct with music moulds,

Schedule - Put act Contact till needle leaves pin coken reach 180° put on 700 lbs for 12 min —
Cool & remove at 125°

The other 6 can be 1412 brushed blanks

moulds, 4 out 24 stick even after soaking Al or KOH.
Possibly mistake made

These blanks which filled 100% #1000, did not give good transfer only 1 OK bal blisters red but this was only at 300 lbs yet when we had Cleaner powder old 1412 gave right along 100% both on transfer & print no swelling at Edges blanks bruished

Up to this point #1000 is the only blanks that filled & printed 100% wherein no Eye defects seen
The only other 100% prints was rsq powder 1/16th thicker blank 500 rugged pressure - & while 100% by listening were very much less by Eye inspection

So far all troubles of every kind & character that we ever had is traced right to blank

To fine powder in relation to the amount of lac produces enormously def results, With 1½ part lac blank flows at Edge & you cannot fill good on 800 lbs pressure
Direct printing - if lac is reduced to 1 part some dont fill at 800 lbs flows out some at Edge With 3/4 part of lac 100% good prints made
At 500 lbs pressure no flow at Edges but sticks to music

This blank with Var on gives blisters
Same blank without Var no blisters
This shows vapor + gas of
Weld Var tends to make
Red blisters & as Var has
closed the pores it cant
get out, -
With this very fine powder
3/4 hac is equivalent to
coarser powder and 1 hac

1033 E

Transfer with Reg Var plates
12 #1000, 3/4 hac req thickness
blanks without brushing
Reg 1412 Schedule 300 lbs
pressure

OK for blisters I
Edge broken II
wholly OK IIII III.
Angle ⟨ direct broken edge I
parallel cks ½ of edge I

Dead flat square edge to this blank

Notes –

Blanks which squash out at Edges probably deform the music.

Note if this is correct against a flat Edge blank –

On a squirting blank that swells at Edges the quality of Music is rotten whereas if a reprint is made the quality is fine — Probably because ~~on~~ Reprint is does not ~~deform~~ or swell any further at Edges –

This is New

Another proof is that #1000 blanks that do not swell at Edges give very fine quality –

1034 E

Hoffman.

Make a quart or two of Weld varnish, with Sandrac and 10% of Lampblack, well ground

I put 5 of these in water May 1 11 am 1916

OK fully ||||

Small spot Opp - dont print, its where stain is from that pull out Moore thinks moulds are defective |||| hollow spot in mould

Crushed Edge ||

This Technique stops flakeing at Edge entirely -

Defects are Crushed Edges + spot poor fill - sharp edged

Moore thinks hollow spots in mould or bad blank

It might be bad varnishing but unlikely as its on both sides -

Quality music OK - surface best yet + perfectly satisfactory - This Varnish technique is OK

After soaking in water 4 hours Edges swell up - But I find that where swelled & turned up, blank has been Cracked or broken at Edge but showed no evidence before put in water 1035 E

2/3rds blank Edges OK - Surface not affected by 4 hours

Varnish 24 #1000 blanks 1510 regular thickness - put 3 Coats on After 1st Coat on both side bake in Fred Otto Oven for 1/2 hour at 130° then put second coat on + bake 1/2 hour. The same with 3rd Coat. used Var 1019E

Print with reg flat music moulds. 12 of them - quiet music

Schedule - Bring to contact needle just off pin. When temp gets to 180° put on 700 lbs for 12 min, Cool down Cold + remove.

NOTE as against 1036

OK for Drop test - & thick

Notes

These records break on 2nd good drop. 4" on hard wood floor

Later another one didnt break in 10 drops

If my green blotting pad put on floor, it drops any number of times OK

Edge veneer flaked, HHT I
fine pull outs in music I
but flaks OK full print both sides HHT III
Crushed Edges II
OK Everything III
Lack of var 1 1/16 spot. 1

All full prints —
flaking of veneer off at Edges in many places clean to music — is main trouble, 2nd trouble is that two records had crushed Edges —

Steam went low
80 lbs —

The small 1/16 spot not filled — Music is due to bad Varnish technique

Not Enough Var + not Enough pressure No 1035
proper technique

1036E

50 Blanks E 1000
Reg thickness of blank

Varnish with 2 coats put on regular way Drying 2 hours after 1st Coat & 1 hour after 2nd Coat. Using Varnish 1019 E

Print 12 with flat music moulds having 2 cracked moulds —

Schedule Put at contact needle left the pin — When temp reaches 180 put on 500 lbs for 12 minutes, cool down cold + remove

Note

1037 E || only in this lot.

Duplicate 1036 E

Only change schedule as pressure is 400 lbs for 12 minutes

OK ||
Poor print both sides ||||
Cones both sides |
Stuck to mould | side only |||
Broken edge Flaked off Edge | side only |

Note 3 stuck to mould - This pressure while it may harden Vac is not sufficiently welded by the low pressure of 400 lbs.

Quality mosaic OK - surface not near as good as 1035 due to 3 Cones + Bake between in 1035

4/30/16

1038E

Hoffman

Make up 75 blanks & 1000

But use 800 lbs on Rubber

[redacted] Reg Rickman

Had to abandon 800

700 lbs is dust as the surface too hard & there is lumps in the scrape off so we can't use powder again without grinding them grinder & screen

OK ~~III~~ II
Commercial III

Black cracked at Edge in 1/2" both side 1

Spot var pulled off on mold 1 side 1.

Commercial is chipped - little on Edges but Edges out,

Quality of Music OK
Surface V + some V V

Put away for time test - flatness, Quality Music. Surface + warping

Note 17 hours

1039 E

1510 Blank
1031 E

#1000 blank.

Varnished twice 1st Coat dried 2 hours

2nd Coat stood all night to dry

17 hours -

Weld Var 1413, Reg -

Print 12 with flat music moulds having 2 cracked moulds -

Schedule, Bring to Contact needle off pin When 180° reached put on 4,00 lbs pressure for 12 minutes - Cool down Cold + remove

Save X seperate to Var Sp at only
" XX " "
XXX

X – OK but big pull out where previously ||

OK. |||

Poor print both sides ||
" one " ~~|||~~ 6mo

1040 E

4th Reprint

Reprint 1024 –

Putting 2 Coats Varn over use 1019 Var.

After 1st Coat dry 1 hour
after 2nd Coat dry 1 hour

Use music mandels ~~& same~~ schedule as 1013 300 lbs –

1041 E

Hoffman

Make dog 1510 blanks - which will be around 180/1000 thick if you can using 800 lbs on Rubber

1042 E

Hoffman

Make every day until notified to stop -

300 blanks ~~[illegible]~~ Jerma Thickness as 1412 210 @ 220

with 800 lbs Rubber pressure

Where to arrange to view these Then keep to Stock Room using 2 Coats Varnish according to best technique - Saving discards for revarnishing & keep records & keep account

These would have printed OK I think on good @ 1000 lbs

Moore thinks moulds sticking blank too then –

Dawsome Edge Cracks on one ?

Music Quality Good –

Surfaces not quite so good as 1035 B

1043 E 180/1000 Thick

Varnish 12 of 1041 by the technique of 1035 – 3 coats & baking between –

Print Reg music moulds

Schedule same as 1035

OK IIII

Poor print ~~Sep Edge~~ both sides. III

Comed

not filled in fine spots mill I

Poor print one side II

50%

May 1st 1916

1035 — 1035 is the

Varnish & Print Technique preliminarily adapted to go ahead with Comel work — Blank 1510

700 lbs on Rubber & 225 @ 225 thickness 98% thru 180 mesh —

5 2-3/4

1044 E 5th Reprint

Reprint 1040 – Same schedule but Var only on bad spots.

Pull outs & forms & specs
are due to air & wet
poor prints in some
cases - - but generally
Uneven Varnishing
& Some Cases the Blank

1045 E

1st Dup

Duplicate 1035
Right along - want several
Duplicates 1st

OK
Poor print near label 3 x 1

Pull out - poor print
" "

OK
OK

OK
OK

OK
OK

poor print few dots
" "

OK
OK

Pull out 1
poor print

Poor print
poor print

50%

Forms bad
Forms

OK
OK

OK
OK

None of Edges broken out

2nd Dup 1035

Poor print small spot
OK

OK
poor print fine specs

OK
poor print fine specs

OK
OK

OK
Pull out 1/4 sqr

41%

OK
OK

OK
OK

OK
OK

Poor print Specs
poor print Specs

OK
Specs

OK Council - pull out on label
OK Crushed blank Edges
Crushed "

Surfaces generally are not very good these are another set of moulds & Vessey - probably the surfaces are as good as req - One of the New tracks ~~[illegible]~~ has a very dead surface which indicates pressures should be increased from 700 to 800 to drummed surface & get better fills

12 | 1" | 1"

3rd Days 1035

{OK
{Specs poor print

{OK
{Pull out & sqi rim -

New set

Quiet World

[OK
[OK] Conch.

{OK
{Specs on one side pr

[OK
[OK]

{poor print
{poor print 1" off

{OK
{Specs

{OK Conch
{OK Conch.

16.5%

{Specs
{Specs Opposite form

{Specs form
{Specs form

{OK
{Form specs -
{poor print
{OK

2nd Print

Reprinted the 4 again on 1000 lbs pressure

OK
OK

OK
OK

Chipped Edge
—"
"

OK - But Satin + not
OK filled in Spaces —
Will put one Coat Var
on + Reprint at 1000 —

Varnished 1 Coat + reprinted at
900 lbs —
1 Coat not Enough - wants
3 Coats, Baked after Each Coat -
Satin marks not Eradicated

poor print
OK

poor print
"

poor print
poor "

poor pt
"

Put 2 Coats on. 2nd Coat blistered
up in oven 130° Fahr - guess he
got higher than 130 -
1 Coat would have been OK
Printed at 1000 lbs -

1 Nearly OK
2 Terms OK
3 Terms OK

4th Dip 1035 —

OK
Term 1/2" near label

OK
Term 1/2 near label

Specs
Specs Both sides op

Specs
Specs Both sides op

1
2
3

4 patched record, Varnish
only put on bad spots
not on balance of record

The patches are generally
OK + Can't see seen - but as
unpatched part was not
varnished + given Satin +
fails to print at places
think 1000 lbs would
make whole record good

4th Dip — 1035

Comed
Comed } pull out some trouble

OK
OK

OK
OK

Ferma
Ferm } opp

OK
OK

fine bubbles 5 of 6
OK

OK
OK

OK
OK

OK
OK

OK
OK

OK
one 005 bubbles on first feedline - trouble point on Kastle

OK
OK

91 0/0

800 lbs pressure

1412 Blanks - 1313 Van Reg

Used to train the Brewsters —

OK
OK

OK
OK Commercial - pulled out in label -

OK
OK Commercial - Edges bad,

Air trapped
" " Moore scoops (fault mold)

Commercial Spur spot ¼ beyond mouth
"

OK
bubbles trapped

Air spot. near label + too close to mouth
" " " " "

OK
OK

OK
OK

Air bubbles
" "

OK
air bubs

OK
OK

50%

NOTE on 1046

Probably want two coats
Each thinner than this &
Dried in oven after each coat.

The single coat put on in
machine is evidently too thick

Air may play an
important parts —

Probably 3 coats
Each thin & baked
after each to get rid
of alcohol & air —

NOTE

1046 E

Reg 1510 blanks Var by Fred
Otto Machine, one coat, Baked

Print Reg Moulds -

Schedule Same as 1035,
but 800 lbs for 12 minutes

OK Comel - pull out at hole.	
poor print poor print	OK OK
poor print poor print	OK poor print. Edge chip
OK poor print	poor print OK
poor print poor print	OK Torn
OK OK	
OK OK	
poor print poor print	

33%

Starts — May 3 1916

Hereafter Hoffman

will adapt 700 lbs

for the Rubber pressure

as 800 lbs Cakes powder &

bathers,

Note – 5th Lot,

It wanted that Extra 100 lbs.

This caused all to fill &
made surfaces a Little better

1510 Surfaces Compared with Req
phased inspection numbers

Req	1510	
Loud	6	none
Rough	2	none
good	10	4
Very good	6 only 6 Very good	11
Very Very good	None	9 20 out 24 surfaces Very good

1 RO – Repairable
2 — 1 Very bad
3 — 1 Bad
4 — 4 fair
5 — 5 weak
6 — 4 Very slight

only 4 RO – 6 weak

Quality of much about the
same probably Req better
but very slight upset | uneslings
more as if there is a deformer its slight

5th Lot 1035 800 lbs

OK
OK — 1 thick bottle ½" to Label
OK
OK
OK
OK
OK
OK
OK
OK
Cornel – Edge crushed away, will edge ok
OK
OK
OK
OK
OK
OK
OK
OK
OK
OK
OK
OK

100%

good 8 surfaces
Very good 11
Very Very good 1

No Run Outs

Tracked
good 2
Very good 2

This look like 850 pressure was necessary as the poor prints are very small in size & a little more pressure would print them out

12 | 80 / 72 / 8 = 66

6th Lot 800 pressure 1510

3 Coats, ovened between each coat —

OK
OK

OK
OK

OK
Comed Edged 1/8 in

OK
OK

good Edges —

Poor Print
Poor Print } of

OK
OK

one 010 round pullout or dirt.
OK

OK
one single 010 bubble

OK
OK

OK
OK

66%

OK
poor print

OK
OK

Note

Small spot at Edges is due to support pins on Varnishing table

Being fixed

1510-

Round #1 Up stairs entirely
3 Coats. 6 hrs
between

OK
OK

Ferns
OK

OK
OK

OK
OK

OK
OK

(one 1/32 veneer gone at 1/8 from Edge
OK

OK
OK

OK
OK

OK
OK.

66 2/3

Really 91%

(one 1/32 veneer gone at 1/4 from Edge
OK

OK
OK

(poor print on Edge small -
OK

Think they are not varnishing Edges Enough - Thin there,

Round 2 upstairs

Concl OK — lack Van at rim

OK — 1/16 dia not felled, lack Van at rim

OK
OK — 1/32 out on rim, but well gauge

OK
OK

OK
OK

OK — Fern at Edge – lack of Van

OK — Fern at Edge " "

60%

Concl OK — Edge blank chipped

Really 100%

OK
OK

OK — 1/4 fern at Edge – lacks Van

10 Prints,

3RD Round —

OK
OK

OK
OK

OK
OK

OK
OK Crushed Edge

1/16-spot cut Edge
OK

OK
OK

OK
OK

Spot 1/16 cut Edge
Term near label

OK
OK

Term in music 1/32 X 1/4"
OK

Door Print
OK

Firmo Edge chipped off
Firmo

58 8/9

Really 83%

4th Round

Term pp | in music

pp

OK
OK

OK
OK

OK
OK

pp
pp

OK
OK

OK
OK

OK
Concl — small spot at Edge maybe in mould like the other

OK
OK

OK
OK

OK
OK

OK
OK

Good Edges.

83%
Really 91%

It is in Mould 2 rounds
show it,

~~With Straight Edge~~
show very flat.

Note.

Should we have any trouble in making reprints on account of Var not sticking or flaking off Condensite Veneer, Its Very quick & Cheap to Sandpaper the Veneer off + start with fresh blank.

Refer to further

5th Round

Poor Print
" "

OK
pp at edge not due to pins

Poor print
" "

OK
OK

poor print
" "

OK
OK

poor print
" "

Comcl
OK — Chipped Edge

Comcl
OK — Chipped Edge

OK
OK — pin dots from Var Table

OK
OK

OK
OK — pins on Var Table.

58%
Really 66%

6th Round

OK
OK

poor print music - form
OK

OK
OK

Form in Music
OK

OK
OK

OK
OK

OK
OK

OK
OK

OK
OK

OK
OK

OK
OK

OK
OK

83%

Edges good

500 times ok

Note

The great wearing qualities of record may be largely due to the Lampblack in Varnish —

Also we should test a Reproducer for several days on new blanks as the Lampblack may wear the Diamond.

7th Record

OK OK	
Cornel OK	chipped Edge
OK OK	
OK OK	
OK OK	
OK OK	
OK OK	long spot on Edge made by Table pin
OK OK	table pin mark
Fern Fern	
fern spec	
OK space in music	

75%

These blanks were used to teach the men how to Varnish & are poorly Var probably.

8th Round

But these are 1412 blanks

1413 Var.

OK
OK — Varnish Table mark

(poor print

(Big Spots } opp
" "

(Big Spots } opp.
"

(Blanked V at Edge
Varnish Table Spot

(Var Table Spots Blank Cracked Edge
" "

(poor print Lace Var
" "

[Big Spots } opp Lack Var
"

[Terns
Terns } opp

[Blank Cracked in Two.

[P Print } opp
"
[P poor print

We buffed a record after Edging —

The Dope used on wheel fills record grooves full —

If Records are to be buffed must use Dry wheel or wheel & powder

May be so much shellac on face that Veneer dont stick well & gets pulled off by mould

This would imply less Lac than 3/4 say

5-2-+6/10 K

9th Round 1412 Blank

Learners trying to Varnish 1413 Var

OK
OK

(Ferns / Ferns } op — in music

(Bare Spots 1/2" Label

(Specs / Specs } op + a fern on 1 side — in music

(Specs / Specs } op.

(Specs / Specs } op — in music

(Specs / Specs } op

(Bad Var at Edge } opp —

(Specs only 4. in mould.
OK

(Fern / Spot } op — at Edge Label.

OK
OK

Blank Cracked before Var put on

NOTE

On some of the moulds

15% large granulations of Vaw runs out on lip over screws & frys up some have none & most only a little —

From Fred Otto think one Coat think should have 3 coats & these except 1st one put on very thin & baked 40 min perhaps 1 hour at 130 @ 135 with draught to get rid of Alcohol & Air —

We would probably have less fry out & forms etc

10th Round but these are 1510 Blanks Raise at Cauls filed down

(OK
forms in music —

OK
OK

OK
OK

OK
OK

(Specs
OK

(Specs
Specs } OK

OK
OK

OK
OK

OK
OK

(OK
forms in music

OK
OK

58%

I notice on the 4 patched records that after the 3rd print no varnish being used on the main parts of the record that on varnishing 2 coats baking after each coat 1/2 hour at 130° that in some place the var did not weld to the condensite surface but flaked off -

Perhaps we are using too much 6/4 and it gets too hard as evidenced by fact of it playing 500 times with no signs by Eye or Ear of wear

Well try 7 $6\frac{1}{2}$ + 5 (6/4) varnish + test this out.

Note.

I think I know now what makes pull out spots + forms.

The record is OK when pressure on but there is gas below + the swells up when pressure is released from mould or when mould is taken away + this cold blister breaks off a piece of the thin veneer.

The remedy is to use 3 thin coats + bake well say 40 min at 130 - to get all the gas out possible.

This may not be true in all cases but I think its so in some —

I noticed under where forms had cracks around one edge -

1047-.

Hoffman

Make me some more say

A a quart of 1019 Var but only use 7 6/4 instead of 7.4

B Also another quart 6.5 6/4

C Another 5 6/4 —

Increase to 850
from 800 seems to tend to
stick Veneer to mould
+ specs flake off -

Cantoay yet

Note 11th Round 1510
850 lbs

OK
OK

OK
specs — These specs all pull outs they stick to mould

OK
OK

OK
OK

specs
specs These stick to mould + are not good prints —

OK
OK

75%

OK
OK

OK
OK — place where Varnish Table pin hit

Cornel
OK — chipped Edge to blank

OK
OK

OK
OK

OK
Veneer along Edge came off within 3/16 of music — cheaper to sidepunch than Edge down

Must have Lampblack Varnish
dont anchor to blank at Edges
+ pulls off in 2 or 3 Cases

Also Varnish not having Lampblack
flows too free in printing +
it flows out over mouldch +
out to the platten of the press
far more than Lampblack
Varnish —

Will have to stick to 5% Lampblack —

Quality Music very good

Dont think surfaces are
as good as 5% Lampblack

1048 E

1510 Blank

Varnish 3 Coats Drying 130° after
Each, put on thin —

Use Regular Transfer plate
Varnish

Use 850 lbs

OK
OK

OK
OK

OK
Comel V chip out at Edge

OK
Big V chip out at Edge

Big Spec groups
" " "

Space
Space not opposite

OK
OK Spaces at smooth part run Dont sound
" "

Veneer at Edges Dont anchor
" "

Veneer at Edges Dont anchor
" "

OK
OK

OK
OK

OK
Big. V chip out Edges

41%

850 lb is best
for full prints
if specs sticking to
mould is prevented

Think it will always
give 91% full prints –

12th Round 850 lbs –

(OK
specs — pulled off on mould –
OK
OK
OK
OK — pin point from Van Taffie
(OK
specs — pulled off on Mould)
OK
OK
OK
OK
OK
OK
OK
OK
OK
OK

No poor prints

66%

100% if stop pull off
on mould

(OK
one spec stuck to mould
(OK
several specs stuck to mould
OK
Correct. Edge chipped

Upstairs

3 Coats. no. 13th Round 850 lbs -

Hole rise on

OK
OK

OK
OK

OK
Cracked — Edge broken

OK
OK

OK
Spec. stuck to mould

OK
OK

OK
OK

66%

OK
Spec stuck to mould

OK
OK

Specs
Specs } stuck to mould

Broken Edge bad
OK

OK
OK

Think Excess Lampblack prevents Var from flowing & filling

Most of pull outs (12) bare spots would not varnishing are at End of music - & are large -

Dont flow -

Just as much Var went over Edge as with 5% Lampblack -

Quality music good
Surface good

1049E

12 1510 blanks

3 Coats Var - Baked 130° 1/2 hour after each coat,

Used 1515 Var 10% Lampblack
Same as other Var with 5% Lam

Print at 850 lbs

(OK pull out 1/2 x 1
(pull out / pull out } opp 1/2 x 1
(pull out / pull out } op 1/2 x 1
(poor print
("
(pull out 1/4 x 1 1/2 | op
("
(OK
(p print near Edge
OK
OK

(specs / specs | op
(Big pull outs | op
(p print " | op
(pull out " | op
(OK
(pull out.

80%

Dup of 1050 E

Moulds were cleaner with Edging but not Enough -

(OK. Stuck to mould specs at Edge

OK
OK
OK
OK
OK
Cracked Edge Broken
OK
OK
OK
OK
OK
Cracked Edge Broken

75%

(Cracked blank Clean across

OK
OK
OK
OK
OK
OK
(Cracked Blank Clean across

Dup 1050E

OK
OK
OK
Cracked Edge Broken
OK
OK
OK
OK
OK
Cracked Edge Broken
OK
OK
OK
Cracked Edge broken
OK
OK

OK
Cracked Edge broken
OK
OK
OK
OK
OK
Cracked Edge broken
OK
OK

100%

Think this lot Vars put on more Even + better inspection of Varnishing + not put on so thick -

1050 E

Moore experiment same as cell Dups 1510 . 850 lbs

But Edged before printing to remove Vars on edge

OK
Cracked - Edge broken
OK
OK
OK
Cracked - Edge a little broken
OK
OK
OK
Cracked - Edge blank broken
OK
OK
OK
Cracked Edge broken
OK
Cracked Edge broken
OK
Cracked Edge blank broken
OK
OK

OK
OK
OK
OK

100%

Moores Spcl Schedule. otherwise like 1512 Deeps — Used 1412 blank
1413 Vas -

Schedule — Press warmed — brought in Contact on 300 lbs for 3 min — then 800 lbs for 12 min

(poor print
" " $2\frac{1}{2} \times 2\frac{1}{2}$ specs

OK
OK

OK
Council Edge bkn

(OK
Chipd Edges broken bad

(OK
Edge broken bad ✓

(OK
Chipd Edges broken bad

41%

(OK
Spec stuck on Mould

(OK
Spec: on Edge

(Specs
Specs } stuck to mould

OK
Council Edge broken

(Specs
Specs } op - area $1\frac{1}{2}$"

OK
Council Edge bkn

Experiment 119-

as 1st 2 Coats put on poor
+ like those back. baked 130 30 min
only last Coat put on carefully
+ baked 130 for 45 min -

Moore

Note Opp page

Reg 1510 850 lbs - Van 1019
But B Coats baked 130° 45 min
between Coats - Van put on more
carefully + thinner -

OK
OK

(Tern
1 spent 005

OK
OK

OK
OK

OK
OK

OK
OK

(OK
Tern small

OK
OK

OK
Comall Edge Bkn

(OK
1.. 005 spec

OK
OK

OK
OK Van Table point

Experiment should be repeated per a penly

75%

May 3rd
7 am-

All new ones from
noon baked at
130° fahr 45 minutes
fan in oven

NOTE

15th Dup 850-
3 Coats 45 min bake

OK
Spec in Music

OK
OK
OK
OK
OK
OK
OK
OK
OK
OK
OK
OK
OK
OK
OK
OK
OK
OK
OK
OK

I notice Edge bulge a little, more than usual

Some Mottle —

91%

14th Deep — 850 lbs
Baked 45 min.

OK
OK
OK
OK
OK
OK
OK
Crushed Edge
OK
OK
OK
OK
OK
OK
OK
OK
OK
OK
OK
OK
OK
OK
OK
OK

91%

Rule fit on block

16th Dup	17th Dup	18th Dup	19th Dup	20th Dup	21st (Inspected)	22nd Lot
850 lb 45 mm 3 Coats					Center rise Removal	Coating not Removed not inspected
OK OK	OK OK	OK OK flake off ½" of Edge	OK Form	OK OK	OK OK	OK OK
Blank Cracked -	OK OK	OK	OK Specs	OK OK	OK OK	OK OK
OK OK	Blank broken	OK Corner V at Edge	Specs Specs	OK OK	OK OK	OK OK
OK OK	OK OK	OK Corner V at Edge	OK Specs	OK OK	Specs OK	Specs Specs
OK OK	OK OK	OK Corner - square Edge off	OK OK	OK Corner, Trimmed at Edge	OK OK	OK OK
OK OK	Specs OK	OK OK - pulled at hole	OK Spec .005"	OK OK	OK OK	Specs Specs
OK Form	OK OK	OK OK	OK Specs	Specs Specs	OK OK	Specs OK
OK OK	OK Specs	OK OK	Cracked Blank	Specs Specs	Specs OK	Form OK
OK OK	OK OK	OK OK	OK OK	Specs Specs	OK OK	Specs Specs
OK OK	OK OK	OK OK	OK Spec .010 - 1 -	Specs Specs	OK OK	Specs Specs
OK OK Corner - Edge Grade	OK OK	OK Specs	Form OK	OK OK	OK OK	OK OK
OK OK	OK OK	OK Crushed Edge	Form OK	OK OK	OK OK	OK OK
		OK Specs		OK Corner form at Left		
83%	75%	75%	16%	75%	83%	50%

Surfaces not quite up to 1510 standard

5 — 1

5 — 1

5 — 1

see if anything changed

Learner - poor Varnish + kiln Scab other

23 (of got Tit not inspected)	24 Tits on not Inspected	25 Tit on not Inspected
1412	1510	1510
Blank	Blanks	Blank
OK OK	OK OK	Specs OK
OK OK	Specs OK	Blank Cracked
OK OK	OK Comel chipped Edge	Blank Cracked
OK OK	OK OK	Specs OK
OK Comel - Edge	OK OK	Blank Cracked
OK OK	OK Comel Veiner off Edge	Blank Cracked
OK OK	OK OK	Blank Cracked
Specs OK	OK OK	Specs Specs
Cracked Blank	OK Comel Fuzzy off Edge	Specs OK
OK OK	OK OK	OK OK
OK OK	Specs Specs	Specs OK
Specs OK	Specs Specs	OK OK
75%	75%	16%

probably didnt Ream Hole

1051 E

Use regular Blanks not 1412 or 1510 but old req

Varnish 3 times + dry 1 hour after each -

Print 1510 Schedule Except 500 lbs

1052 E

Dup 1051

Except change pressure to
700 lbs 150 lb schedule

Breaking Test.

1510 blank. Var 3 coats baked 30 min 130° Fahr,
Music direct.
Reg Schedule 850 lbs – This is one of the many Drops made Many 2nd

My desk pad one thickness green blotting paper on Strawboard – Leather Corners – Laid on hardwood floor
Records dropped flat heigth of 5 feet, Drop 13 Discs –
Stopped at end 20 drops

20
20
20
20
20
20
3
20
1
20
1
20
5

Break straight across hole in 2 pieces

Duplicate of 1253

OK OK	OK OK
OK OK	OK OK
OK OK	OK OK
Spec 1 005 – OK	Specs 2 Specs 2
spec 1 010 OK	OK OK
Cmcl OK blen Edge	OK OK

press 41

Oil on label
Edges Very clean

75%

around the Map

1053 E

~~Hoffman~~ 1

Press 24 of 1510 blank only 800 lbs in final press.

Give to Moore to Run Thru 1510 Reg 3 Coat process

130° Fahr Baked one hour between Coats 850 lbs final pressure

Oil on label

OK Cmcl Edge broke	OK OK
OK OK	Specs Low Var S. point
Specs 3 only (fine) OK	Bond OK
OK OK	OK OK
OK OK	OK OK
OK OK	
Spec – OK	

press 41

66%

around the Map

3 Coat 1 hour

Req. 1510 Schedule 850 lbs
flush out hole

Press 40

OK
OK

Oled Label - Seasons

OK
OK

OK
OK

Best surfaces yet
up to May 4/1916.

OK
OK

Comed OK — veneer at Edge pulled off

Spec end of music one only
OK

OK
OK

Good 1
very good 10
Very Very good 12.

OK
OK

Quality of music fine

OK
OK

OK
OK

91

Comed OK — Edge bkn

OK
OK

Wake up America

1054 E

Hoffman

Make 24 1510 blanks
Only pressed 600 lbs in the
big powder presses
Give to Moore to run thru
req 1510 3 Coat Var process.
130° Fahr Baked one hour
850 lbs final pressure

Dup 1054 Press 40 Clean Edges nearly all on board.

OK
OK

OK
OK

Old folks at Home

OK
OK

OK
OK

OK
OK

Comed OK — veneer pulled off at Edges
V bad Edge

Low Var Edge
OK

OK
OK

OK
OK

OK
OK

Var pucked off Edges discard
not enough Var 1st Coat
OK

OK
Edge broken Too much

OK
OK

6/6/8/0

May 4th - Use 3 Coats
Inspect well -
Bake 1 hour after each
Coat -
Remove the raise at the
Center hole.

Use 2 sets new music mould
New - Keep 2 Tracked moulds
records Each lot, Mark the
rounds these 2 lots of moulds
used on -

Around the Map # 4491 – C-19

Wake up America # 4620 – C-61

Hardly any ooze on edges
fine outer edge – no crushed Edge

1510 Blank flush Center 700 lbs Rubber

1st Coat all over blank
2nd " 1/4" from edge blank
3rd " 1/4 "

Wake up America Set

OK OK
OK OK
OK OK
OK OK
OK OK
OK OK
OK OK
OK OK
OK OK
OK OK
OK OK
OK OK

100%

"Around the Map set
// Records

Dup

OK Crushed Edge after Veneer pull off
OK Comet - Edge broken
OK OK
OK Form
OK OK
OK OK
OK OK
OK OK
Spec OK
Crushed Edge V
Edge crushed all around 1 side

50%

1510 3 Coat 700 Rubber	1510 700 Rubber	28th Drys
26th Drys flush Cauls 3 Coat	27 - flush 3 Coat baked 1 hour	Baked 1300 1 hour flush at Cauls 3 Coats
Specs OK	Specs OK	OK OK
Big Pullout Specs	OK OK	OK OK
Pullout OK	Specs Specs	OK OK
OK OK	OK OK	OK OK
OK Comel Edge bkn	OK OK	OK OK
OK OK	OK Comel veneer at Edg flaked	OK OK
Pullout wood spot	OK OK	Specs OK
OK OK	Specs OK	OK OK
Specs Specs	OK OK	OK OK
OK OK	OK OK	X Defect in blank
OK OK	Specs OK	OK OK
OK Comel bikn edge	OK OK	
Coat 1/2 hour 2nd 1/2 3 3/4		
58%	66%	81%
Around the Map	Stop Look & Listen 4512-C-59	Around the Map
1510-2 Lot	1510-3 Lot	

1510 Hoffman

Lot 1 & 2 are 6 Cauls made with 800 lbs Rubber pressure

Lots beginning # 3, are made with 700 lbs Rubber pressure

Started 5-3-16

Blanks 1510 Lot 2
Brushed 2 coats by Fred Ott on his
brush Machine - not with Cones.
130° 1/2 hour -

OK
OK

Specs
Specs

OK
Not filled at Edge

OK
Not filled Edge

OK
Not filled near label

OK
OK

Specs
OK

Not filled
OK

25%

Dup 1055 Except oil all over
the surface,

OK
OK — big pull-out Lots Horrible

OK
OK — piece wood in

OK
OK

OK
OK — press 41

OK
OK

OK
OK

OK
OK

OK
OK

OK
OK

Around to Mate

100%

Horrible surfaces -

Poor Varnishing

2/19/87

1055 E

Var 3 coat bake 1/2 hour

24 of our Reg production
blanks — These are blank which
we put transfers on

Print Same as the above

as 1510 - 3 coats 1 hour
press # 40 - oil on label.

OK
OK

OK
OK

OK
OK

fine specs
OK

Low Var
OK

OK
OK

1 small spec 010
OK

OK
OK

OK
OK

OK
OK

OK
OK — Stuck + pulled out at Rafo

OK
OK

75%

The surfaces
are very bad
14 faces all rated
Loud & rough

Old folks at Home -

6 6/4 Press 41

All Inspected

1510-flush

Lot A Varnish of 1047 E 3 coats

Req 1510 schedules

B2	C1	C2
OK OK	OK OK	OK OK
OK OK	OK OK	Specs Specs | not OK
OK OK	OK OK	OK OK mound defect
Comp OK Edge broke	OK OK defect in blank	Ferns OK
OK OK	OK Comp Edge broken	
Low Var OK	OK OK	
OK OK	Specs small OK	Poor Varnished blanks — cledent present Rem —
Specs Specs | OK	OK OK	
Big fern, near label OK	OK OK	
OK OK	Comp OK Edge broken	
Fern near label OK	Ferns Specs - stuck	
OK OK	Ferns OK	
12	12	
Old folks at Home	75%	50%
66%	Old folk at Home	

A	A Var	B Var 6.5 6/4
11 Recorded A	11 Recorded	
OK OK	OK OK	OK OK
OK OK	OK OK	Specs OK
OK OK	Specs OK	OK OK
Specs OK	OK OK	OK OK
OK OK	OK OK	Specs OK
Specs Specs	Specs Specs	OK OK
Specs OK	OK OK	Specs OK
OK OK	OK OK	OK Comp chipped Edge
Specs Specs	Specs Specs	OK OK
OK OK	OK OK	OK OK
OK OK	11	
Old folk at Home 3544 - 5-4-56	Olds Folks at home	
63%	72%	70%
7	6/4	

29th Deep flush at hole — 3 coats 1 hour dry

OK Coated - at Edge slight flaking of veneer - crushed Edge

OK
OK

Spear
OK

OK
OK

Bang spot not flowed ½

OK
OK

OK
OK

OK
OK

OK
Bang 1½" bare spot low Vac measure labeled

8 Blanks — 4 Thrown on

bad Vacuum

Stop Look & Listen

62%

May 4/16 - 100 heat
3 coil
1510 - Lat 3

30th Dup

Wake up America -

OK
OK

OK
OK

OK
OK

OK
Comal Edge brake

OK
Comal Edge brake

OK
OK

OK
Comal Edge brake

OK
OK

OK
OK

OK
Comal Edge Brake

OK
OK

OK
OK

100%

This is 2nd 100% with
Wake up America -

14 men to a leg this includes the final press men —

67 other men on 2 shifts
1 takes care of all the other things

One leg does 3200 22 hours 14 men on a shift - this include big pressman, includes leg foreman

We have 6 legs -

1 leg ok for 1510 blanks -

Can run 1½ legs with moulds we have, any further Extension must have moulds made,

Hoffman wants big special fine woven bags to store his fine powder

125 girls 150 blanks Complete daily 19200
3 Coats both sides - .97 cent blank

This totals 7.39 cents for blank reading to print,

Print .5 cent.
Clean Moulds .8
Inspection .35

8.52 c
.35
8.87

Direct Print

Blank 1510 or £1000
20 000 blanks -

64.5% fibre
25.8 Chalk
9.6 Shellac -

12000 lbs	fibre		126,00
4800 "	Chalk		34,00
1870 "	Lac		374,00
30	gals alcohol		19 00
130	phenol	100 lbs Resin	180 00
			$ 683,00

3.415

Alcohol loss in powder 20% not included — 125 gals day is lost daily -

Labor moulding 1.85 67 men

Other Labor .74

5.899 c blank
.430
6.329 - includes loss of

8)20(2.5
16
40

11)80(7.3
77
30

11)90(8.1
88
20

11)70(6.3
66
40

11)80(7.2
77
30

10)

0/0

12	100
11	91
10	83
9	75
8	66
7	58
6	50
5	41
4	33
3	25
2	16
1	8